DEPARTMENT OF TRANSPORTATION

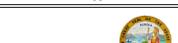
DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection

Bay Area Branch 690 Walnut Ave.St. 150 Vallejo, CA 94592-1133 (707) 649-5453

(707) 649-5493



Contract #: 04-0120F4

Cty: <u>SF/ALA</u> Rte: <u>80</u> PM: <u>13.2/13.9</u>

File #: 69.28

WELDING INSPECTION REPORT

Resident Engineer: Siegenthaler, Peter Report No: WIR-020282

Address: 333 Burma Road Date Inspected: 12-Oct-2010

City: Oakland, CA 94607

Project Name: SAS Superstructure OSM Arrival Time: 700
Prime Contractor: American Bridge/Fluor Enterprises, a JV OSM Departure Time: 1900

Contractor: Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island Location: Shanghai, China

CWI Name: CWI Present: Yes Yu Dong Ping, Qiu Wen No **Inspected CWI report:** Yes No N/A **Rod Oven in Use:** Yes No N/A N/A N/A **Electrode to specification:** Yes No Weld Procedures Followed: Yes No Yes N/A **Qualified Welders:** No **Verified Joint Fit-up:** Yes No N/A N/A Yes N/A **Approved Drawings:** Yes No **Approved WPS:** No Yes No N/A **Delayed / Cancelled:**

Bridge No: 34-0006 **Component:** OBG/TOWER

Summary of Items Observed:

On this day CALTRANS OSM Quality Assurance (QA) Inspector Umesh Gaikwad was present during the times noted above for observations relative to the fabrication of the SAS Superstructure being performed by Zhenhua Port Machinery Company (ZPMC) at Changxing Island in Shanghai, China. QA observed and/or found the following:

ULTRASONIC TESTING

OBG SEGMENT 10AE-10BE ABF Report No: UT-13E-001R1

This QA Inspector performed verification Ultrasonic Testing (UT) in accordance with ABF/CT Pattern "D" UT Procedure 001 Revision 1. All recordable Indications if found were recorded on a separate data sheet that Caltrans QA generates after performing a joint inspection with ABF ultrasonic testing personnel. The location of the inspection was identified as the bottom plate transverse seam weld of OBG lift 13 East segment 13BE and 13CE. The weld designations were as follows:

OBE13C-001

This Quality Assurance (QA) Inspector observed the following work in progress:

BAY #11

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

FCAW welding of weld joints 008 located on BK004A1-019.

Welder is identified as 040759. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-T-2231-B-U2-F.

SMAW welding of weld joints 025 located on BK004A8-018.

Welder is identified as 040690. ZPMC QC is identified as Mr. Shao Hai Lang.

The welding variables recorded by QC appeared to comply with WPS-B-P-2113.

BAY #10

FCAW welding of weld joints 016 & 17 located on BK004A6-030.

Welders are identified as 057180 & 040302. ZPMC QC is identified as Mr. Li Peng Fei.

The welding variables recorded by QC appeared to comply with WPS-B-T-2132.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

Summary of Conversations:

Only general conversation was held between QA and QC concerning this project.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang: 15000422372, who represents the Office of Structural Materials for your project.

Inspected By:	Gaikwad,Umesh	Quality Assurance Inspector
Reviewed By:	Carreon, Albert	QA Reviewer